

**Work Order ID 59363**

Wednesday, June 02, 2010 1:17:26 PM

Page 1

Item ID: D3574-6

Accept

Revision ID:

Item Name: Cabin Floor Protector

Start Date: 6/2/2010 Start Qty: 3.00

Required Date: 6/9/2010 Req'd Qty: 3.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: RFDate: 10-6-02 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3574

Rev B

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3574 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-  
Deburr if necessaryB10-67

(3)

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B10-67

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

S w o b e l o r

(x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Page 2

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Deburr if necessary.

0.00

0.00

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150



Packaging

Packaging

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

Memo

0.00

0.00



Setup Start



Stop



Run Start



Stop



E 5/10/06/08 (3)

S 6/6/06

(B)

PP 59361

10-6-08 SP (3X)

W/O:		WORK ORDER CHANGES					
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Page 3

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Required Date: 6/9/2010 Req'd Qty: 3.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/06/09 *[Signature]*  
Pl 10-6-08  
(3)

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, June 02, 2010 1:46:01 PM

Page 1

Work Order ID: 59363



Parent Item: D3574-6



Parent Item Name: Cabin Floor Protector

Start Date: 6/2/2010

Required Date: 6/9/2010

Comments: IPP Rev :A New Issue 07.07.23 EC verified by:JLM

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No				sf	1,769.706	33.6	100.8504			



810-6-7

GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

MAT

1769.7068

111710

64

112585

173.383

114032

1532.3238

114032

(3)

W/O:		WORK ORDER CHANGES					
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>59363</b>
<b>Description:</b> Cabin Floor Protector		<b>Part Number:</b>	<b>D3574-6</b>
<b>Inspection Dwg:</b> D3574	<b>Rev:</b> B	<b>Page 1 of 2</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.004	Y			
7.37	+/-0.030	7.37	Y			
11.00	+/-0.030	11.00	Y			
15.25	+/-0.030	15.25	X			
25.87	+/-0.030	25.87	X			
39.75	+/-0.030	39.75	X			
44.75	+/-0.030	44.75	Y			
58.38	+/-0.030	58.38	X			
63.50	+/-0.030	63.50	X			
65.25	+/-0.030	65.25	Y			
10.25	+/-0.030	10.25	X			
11.87	+/-0.030	11.87	X			
14.75	+/-0.030	14.75	Y			
26.00	+/-0.030	26.00	Y			
40.87	+/-0.030	40.87	X			
45.00	+/-0.030	45.00	X			
48.00	+/-0.030	48.00	X			
55.13	+/-0.030	55.13	Y			
61.25	+/-0.030	61.25	Y			
61.88	+/-0.030	61.88	Y			
64.63	+/-0.030	64.63	X			
1.13	+/-0.030	1.13	X			
7.63	+/-0.030	7.63	X			
11.00	+/-0.030	11.00	X			
22.10	+/-0.030	22.10	X			
22.50	+/-0.030	22.50	X			
24.50	+/-0.030	24.50	X			
35.13	+/-0.030	35.13	X			
36.50	+/-0.030	36.50	X			
40.00	+/-0.030	40.00	X			
41.88	+/-0.030	41.88	X			
43.63	+/-0.030	43.63	X			
6.75	+/-0.030	6.75	X			
9.50	+/-0.030	9.50	X			

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	59303
<b>Description:</b> Cabin Floor Protector		<b>Part Number:</b>	D3574-6
<b>Inspection Dwg:</b> D3574 <b>Rev:</b> B		<b>Page 2 of 2</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.38	+/-0.030	10.38	✓			
14.50	+/-0.030	14.50	✓			
16.75	+/-0.030	16.75	✓			
18.94	+/-0.030	18.94	✓			
19.00	+/-0.030	19.00	✓			
24.13	+/-0.030	24.13	✓			
33.88	+/-0.030	33.88	✓			
39.50	+/-0.030	39.50	✓			
40.25	+/-0.030	40.25	✓			
43.50	+/-0.030	43.50	✓			
46.60	+/-0.030	46.60	✓			
0.125	+/-0.010	0.133	✓			

<b>Measured by:</b> RB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10-6-17	<b>Date:</b> 10/6/17	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DD	
B	09.05.15	Dimensions updated per Dwg Rev B	KJ	

W/O:		WORK ORDER CHANGES					
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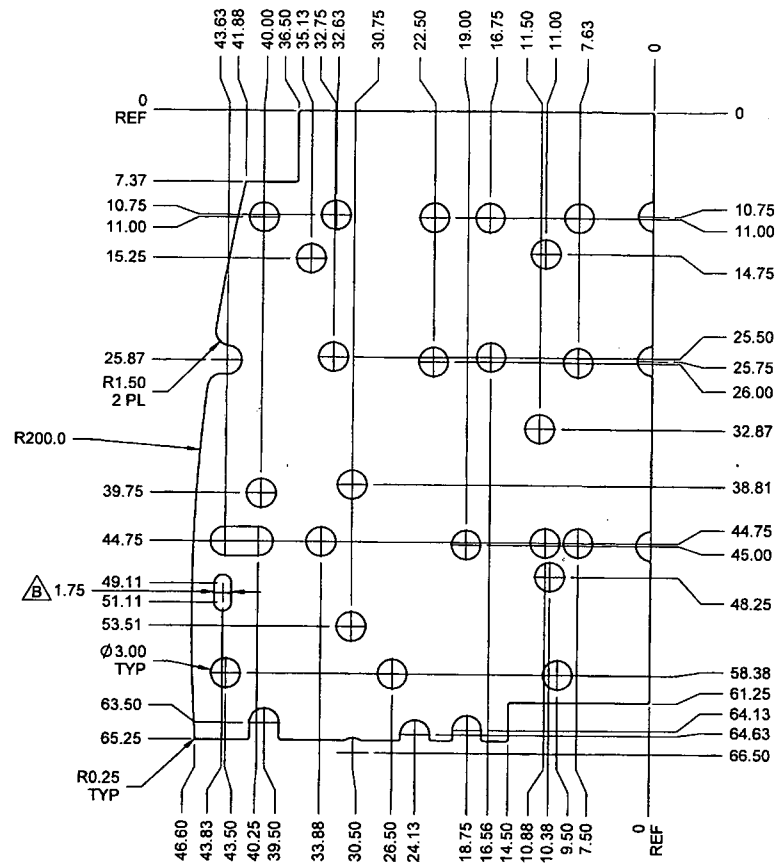
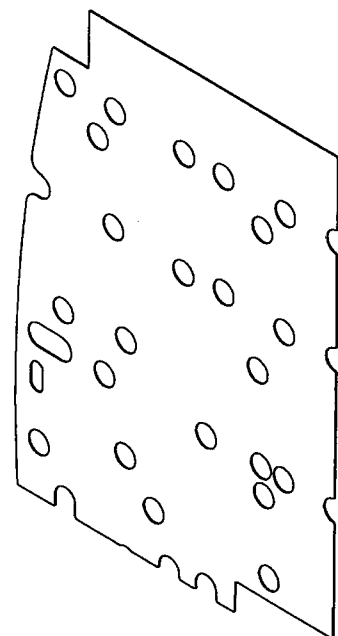
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**NOTE:** Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 59363

*PLC-6-02*



0.125  
REF

**RELEASED**  
09/03/07

**D3574-1 CABIN FLOOR PROTECTOR**

**NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

B	ADD CUT-OUT TO -1/-5 FOR WEIGHT AND BALANCE DATA PLATE ZN B7-1, B8-5, -2 NOW SHOWN ON SHEET 2	09.03.25
A	NEW ISSUE	07.06.08
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.03.25	

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3574</b>	REV. B
TITLE <b>CABIN FLOOR PROTECTOR</b>	SCALE NTS
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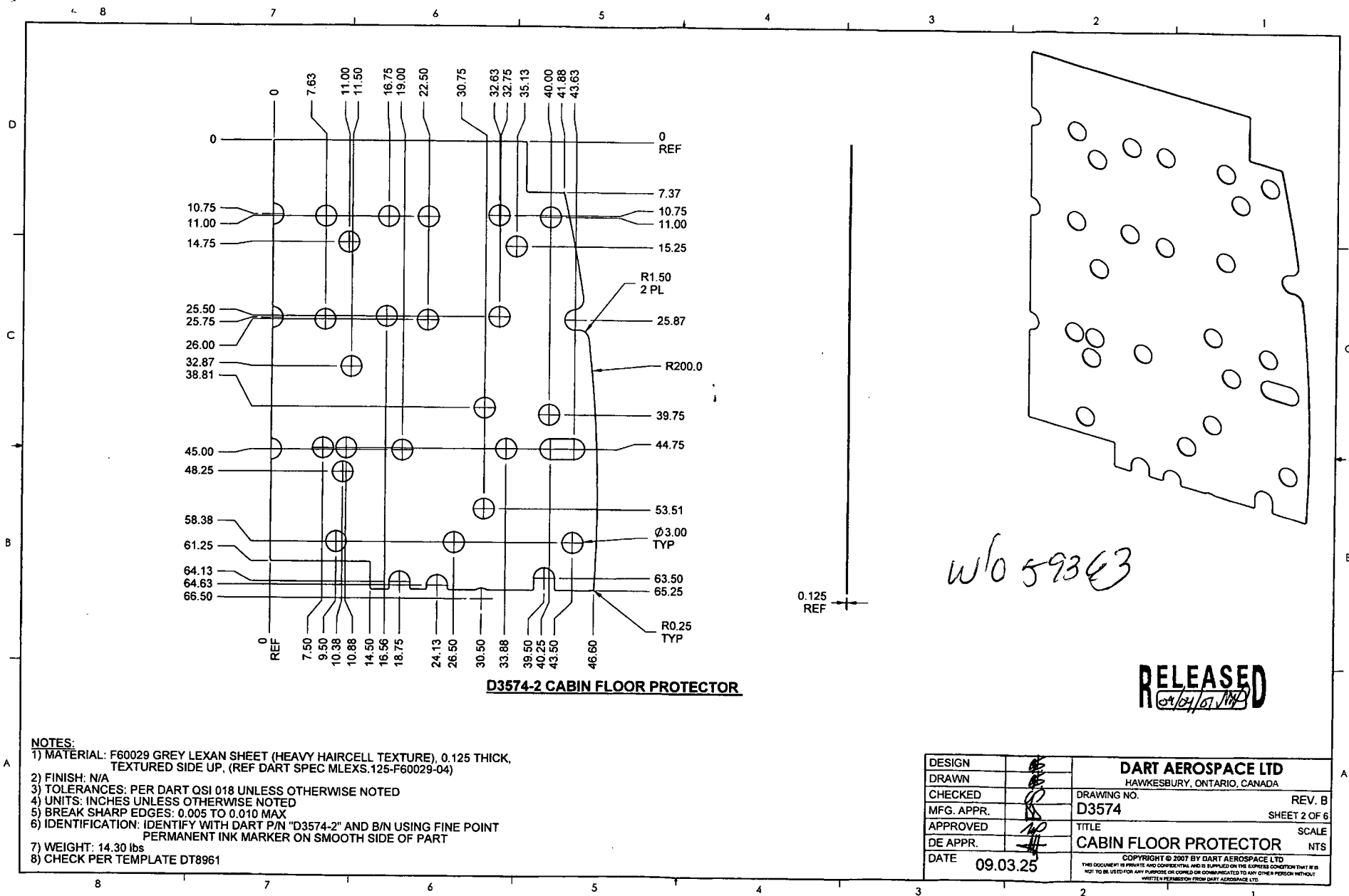
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**NOTE:** Date & initial all entries



W/O 59343

**RELEASED**  
 07/04/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

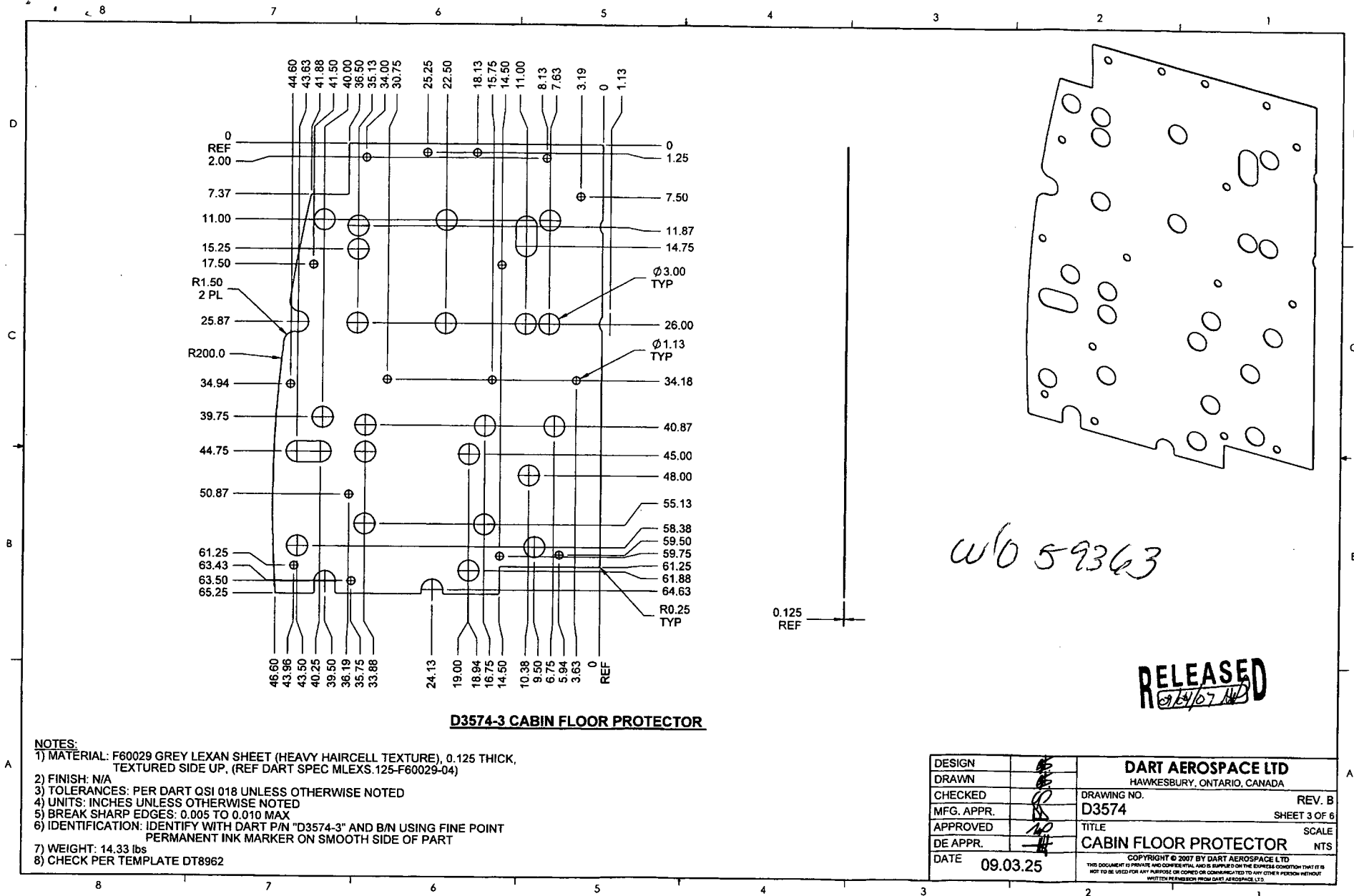
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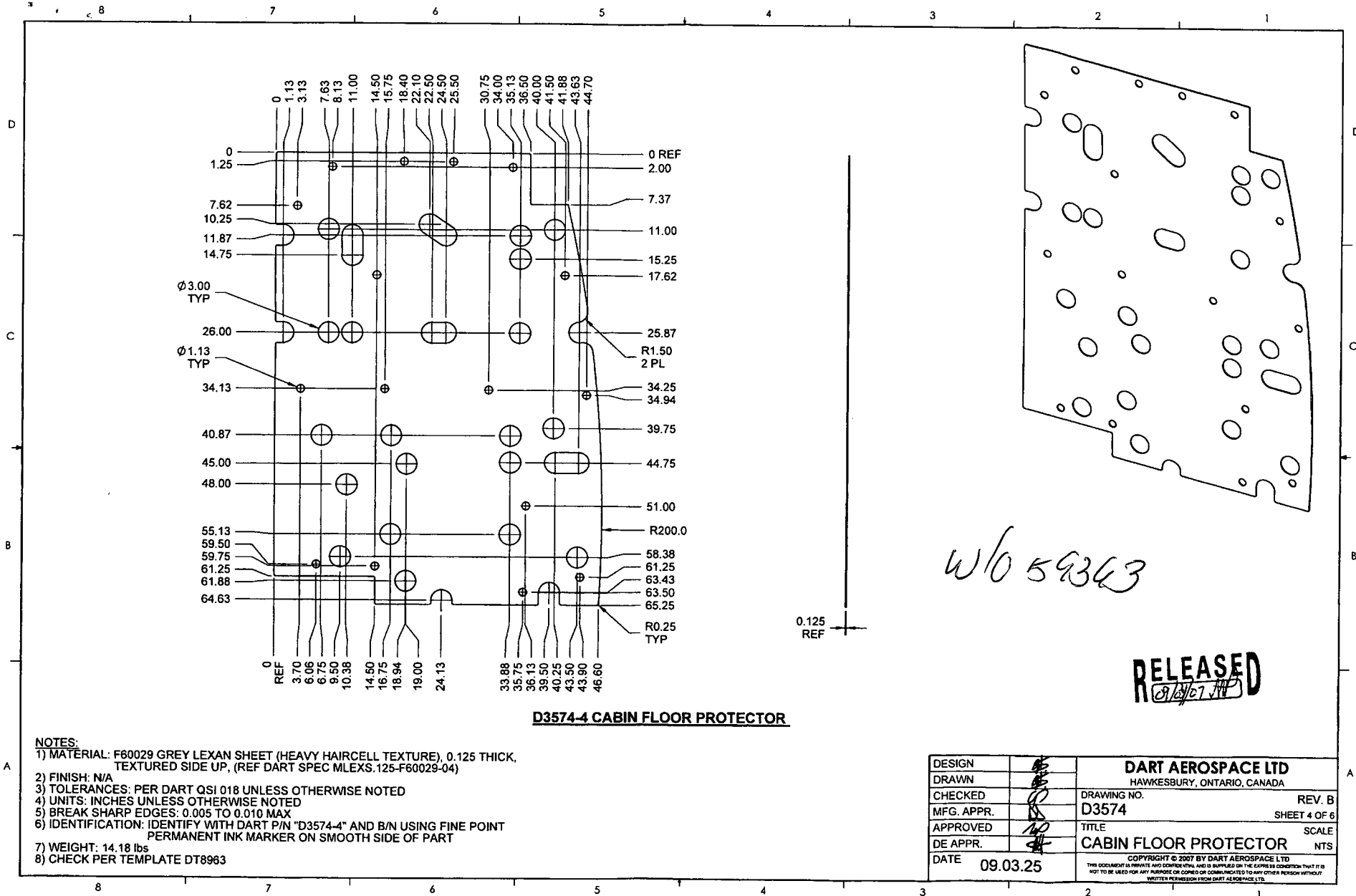
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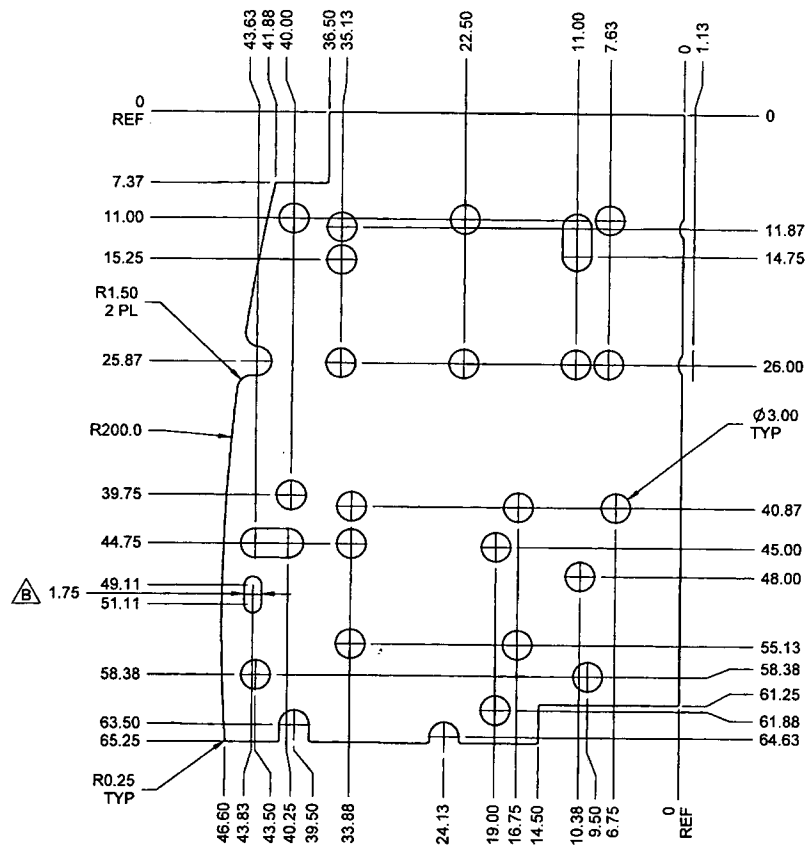
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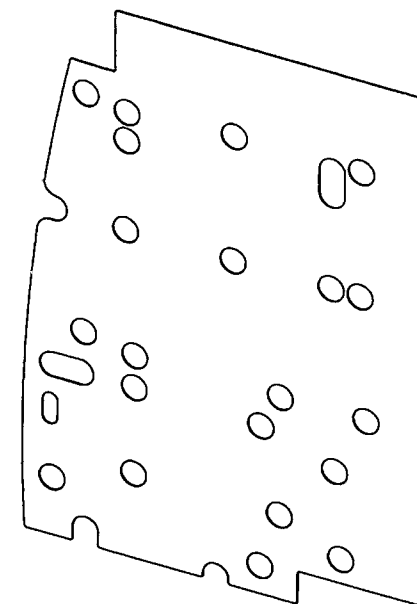
**NOTE:** Date & initial all entries



**D3574-5 CABIN FLOOR PROTECTOR**

**NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-5" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.38 lbs
- 8) CHECK PER TEMPLATE DT8964



W/O 59303

**RELEASED**  
21/04/07

DESIGN	<del>JS</del>	<b>DART AEROSPACE LTD</b>	
DRAWN	<del>JS</del>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>JS</del>	DRAWING NO.	REV. B
MFG. APPR.	<del>JS</del>	D3574	SHEET 5 OF 6
APPROVED	<del>JS</del>	TITLE	SCALE
DE APPR.	<del>JS</del>	CABIN FLOOR PROTECTOR	NTS
DATE	09.03.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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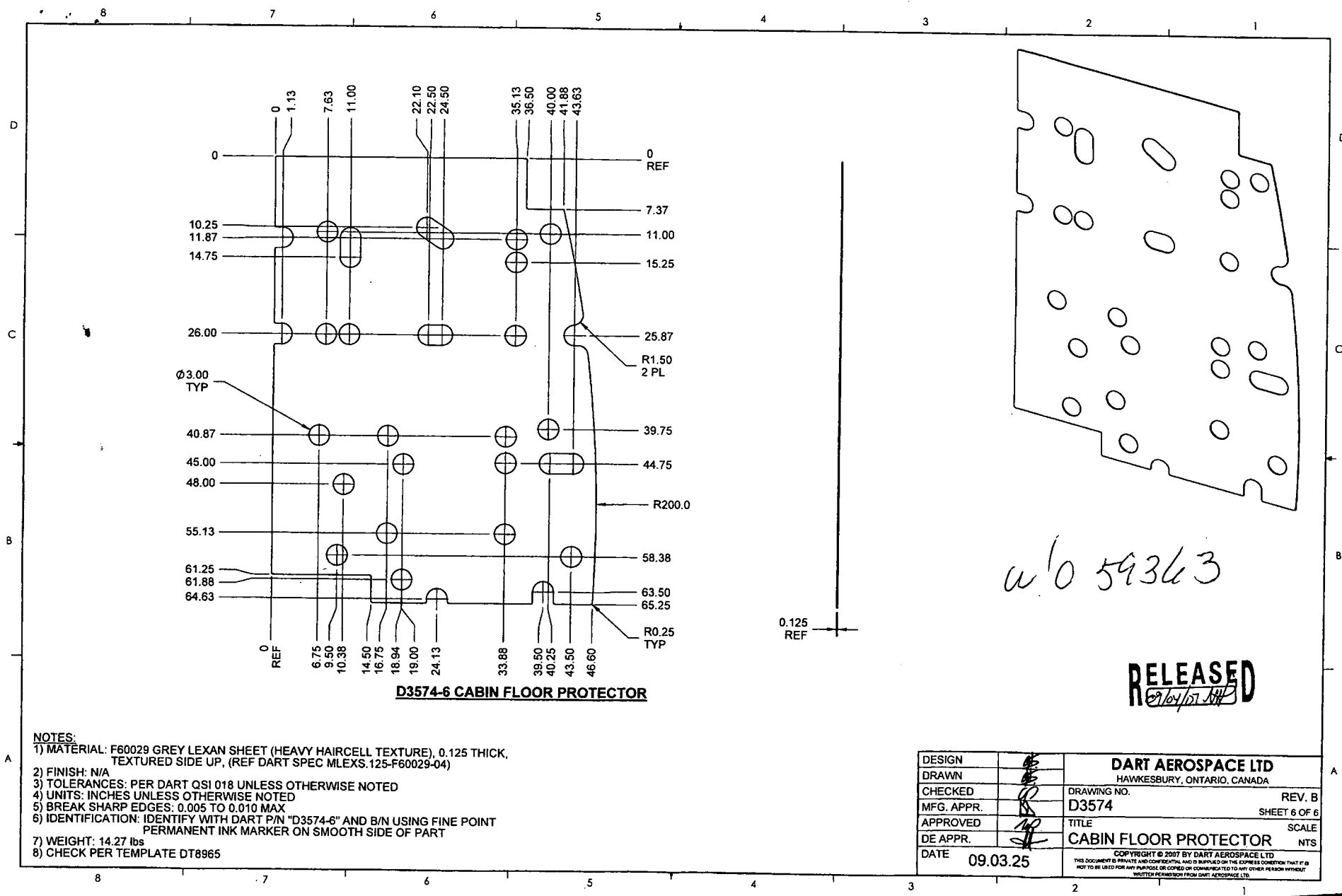
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